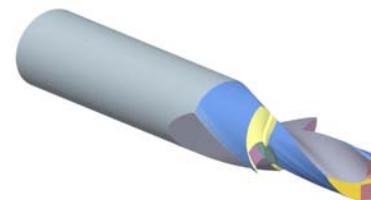


Dowel Stepdrill Ø6-Ø10 Z2

A16-580

This Dowel Stepdrill, doted with precutters on the end and the step, is ground in one setup from a solid blank of Ø10 mm.



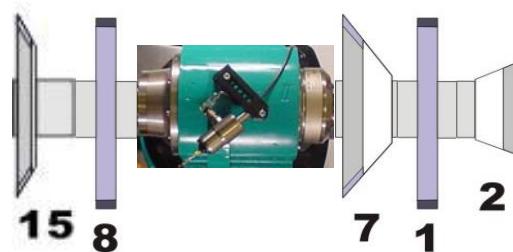
1. Cycletime for Production

Tool specifications Ø6-Ø10, Length 30 mm, Step-L 14 mm, Helix 30° Material CARBIDE									
Operations	Probe	Flute 1	Diam. Pregr.	Point + Prec.	O.D.3	O.D.2	End 2	Step 1	Precut. Step
Feed [mm/Min]	2000	55	25	100	60	80	60	120	60
Power [kW]		3	2	1	1	1	1	2	1
Cutting feed [m/s]		17	17	24	24	24	24	24	24
Used wheels									
Used wheels	1	1	7	8	8	2	2	2	15
Grinding time [s]	20	92	185	38	73	56	24	195	72
Total cycle time	12 Min 34								

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

- 1 Ø125 1A1 D64
- 7 Ø125 12V9 D64
- 8 Ø150 1A1 D64
- 2 Ø75 11V9 D76
- 15 Ø125 1V1 D64



3. Machine and Software Requirements

- | | |
|-----------|---|
| Machines: | 5 axes CNC grinders : GEMINI DMR, NORMA CFG |
| Control: | Fanuc 160i |
| Coolant: | Synthetic Oil, pressure 6 - 7 bar |
| Software: | Quinto 4.3, DXQ |

responsible engineer: OP,9.1.08

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